

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020604**Date Inspected:** 26-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Mr. Geng Wei		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

Magnetic Particle Testing (MT)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 07500. The member(s) is/are identified as Longitudinal Diaphragm to Bottom Plate. The weld designations reviewed are as follows:

SEG3015N-217, 218, 245, 246, 259, and 260

SEG3015N-141, 142, 155, and 156

SEG3015N-223, 224, 240, 253, 254, 267, and 268

SEG3015N-213, 214, 228, 235, 249, and 250

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SEG3015N-117, 118, 131, 132, 151, and 152

SEG3015N-119~122, 147~150

SEG3015N-229, 230, 219, 220, 247, and 248

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of fillet weld joint(s) located on U-Rib to Diaphragm plate identified as DP3080-001 weld number(s) 148, 149, 150, 151, 152, and 153. Welder is identified as welder no. 044790. The welding variables recorded by ZPMC QC identified as Mr. Zhong Gou Hui appeared to comply with applicable WPS(s) WPS-B-T-2133 ESAB.

FCAW welding of fillet weld joint(s) located on U-Rib to Diaphragm plate identified as DP3080-001 weld number(s) 344, 345, 346, and 347. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Mr. Zhong Gou Hui appeared to comply with applicable WPS(s) WPS-B-T-2133 ESAB.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3104-001 weld number(s) 248. Welder is identified as welder no. 067949. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233ESAB.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3076-001 weld number(s) 028. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233ESAB.

FCAW welding of complete joint penetration weld joint(s) located on U-Rib to Diaphragm Plate identified as DP3078-001 weld number(s) 028. Welder is identified as welder no. 052696. The welding variables recorded by ZPMC QC identified as Zong Guo Hui appeared to comply with applicable WPS(s) WPS-B-T-2233ESAB.

During random in process inspection of the Orthotropic Box Girder (OBG) Deck Plate member identified as DP3081-001 this QA observed cracked tack welds on weld joints 096, 104, 156, and 157 joints identified as 2 and 3F fillets. This QA marked the cracked tack and informed ZPMC Quality Control (QC) identified as Mr. Zong Guo Hui of this issue. Mr. Hui informed this QA that the cracked tacks would be corrected in a manner compliant

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with the contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
